

Date: Wednesday, 4/5/2006 3:33:36 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 412 WEB
 Job Number : 26589
 Estimate Number : 10466
 P.O. Number : N/A Part Number : D33891
 This Issue : 4/5/2006 S.O. No. : N/A Drawing Number : D3389 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C
 Previous Run : 26537 Material : N/A
 Due Date : 4/24/2006 Qty: 6 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06.04.06
 Comment : Est Rev:A 05.08.31 New issue KJ/JLM
 Est Rev:B 06-02-08 As per Rev C JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25003100 Ext'n -1' Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Ext'n -1' Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
1	D2500-3-100	Web Extrusion	619074 RT 06-04-07

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3389

RT 06-04-07 (6)

2-Drill pilot holes using DT8785 as per Dwg D3389

RT 06-04-07 (6)

3-Open 1X .257" Dia Hole

RT 06-04-07 (6)

4-Open Remaining holes to finish size as per Dwg D3389

RT 06-04-07 (6)

5-Deburr

RT 06-04-07 (6)

3.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

BE 06-04-07 (6)

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

RT 06-04-10 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 26/04/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 WEB

Job Number: 26589

Part Number: D33891

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-04-11 (6)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG RT 06-04-11 (6)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

RT 06/04/11 (6)

Job Completion



U 06-04-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

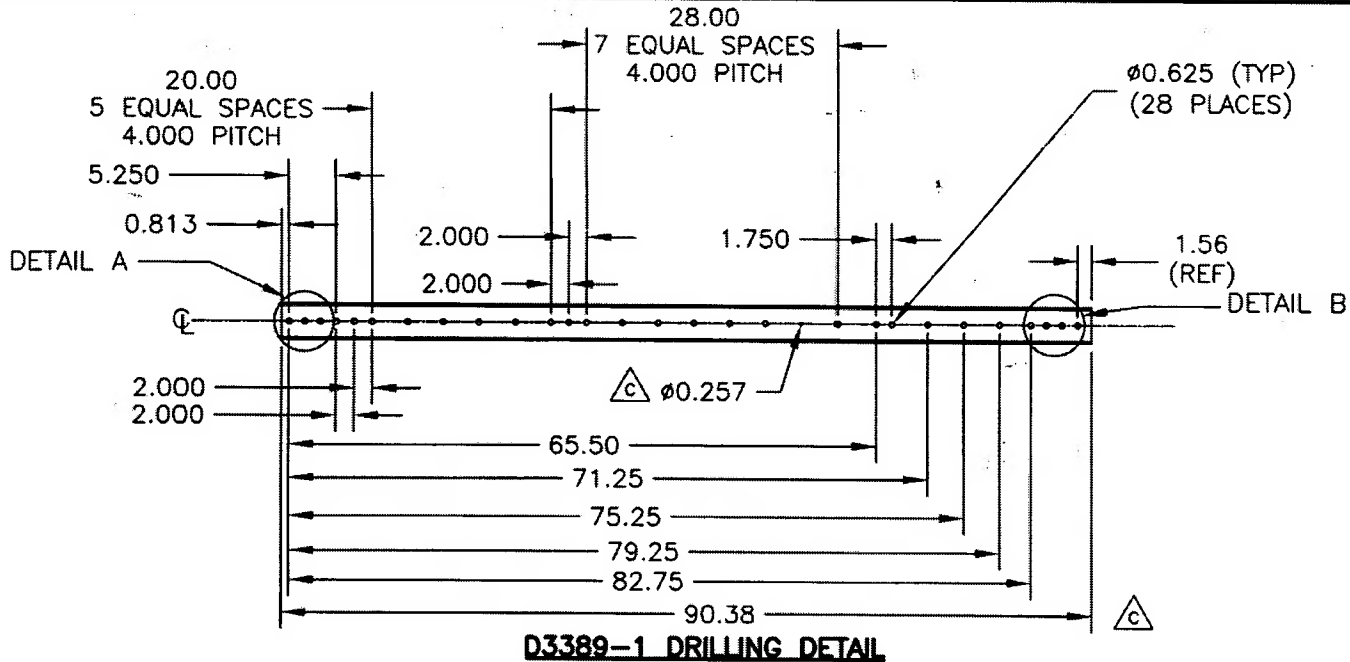
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

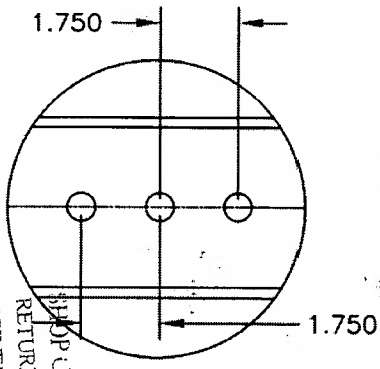
DART

RELEASE
06.01.23

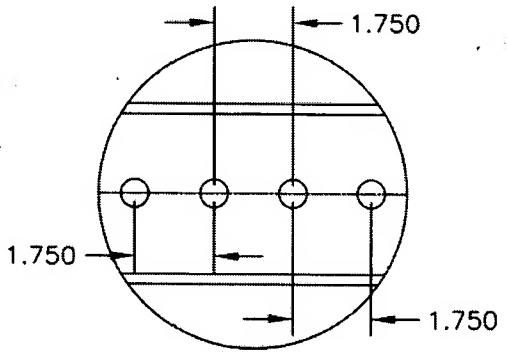
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.01.23	TITLE	412 WEB	SCALE 1:20
A	05.02.07	NEW ISSUE		
B	05.06.13	UPDATE DIMENSIONING		
C	06.01.23	DECREASE OVERALL LENGTH, MODIFY HOLE		



D3389-1 DRILLING DETAIL



DETAIL A
(SCALE 1:4)



DETAIL B
(SCALE 1:4)

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26587

D3389-1 412 WEB

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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